



Dart Aerospace Ltd.
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Canada

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D2282-5

Job Sheet 183579



Part No: D2282-5

Job Qty: 60 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining		
100	Doosan	60 pcs	10/12/18	10/12/18	0.03	9.33	Doosan		
120	QC	60 pcs	10/12/18	10/12/18	0.00	0.00	QC8		
130	Packaging	60 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3		
140	QC21-SA	60 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA189
Descriptions: 130 - *****STOCK IN LARGE FAB*****

DAS 21 9-89 NOV 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	10.8036 ft (12.18 1203ea)	90-Start up Operation	5116714 176

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R0.750	11	40	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches ± 0.030	2.200 2.140	2.169	
2	Handle Tube	0.063Inches ± 0.010	0.073 0.053	Radius	R.0625
3	Handle Tube	0.063Inches ± 0.010	0.073 0.053		.0625
4	Handle Tube	0.125Inches ± 0.010	0.135 0.115		.120
5	Handle Tube	0.090Inches ± 0.010	0.100 0.080		.088
6	Handle Tube	45.000Degrees ± 0.000	45.000 45.000	Angle	45
7	Handle Tube	0.350Inches	0.360	Radius	.35

NOV 12 1904

			+ 0.010	0.350	
			- 0.000		
8	Handle Tube	0.158Inches	± 0.010	0.168 0.148	.156
9	Handle Tube	0.386Inches	+ 0.005 - 0.000	0.391 0.386	Diameter .387
10	Handle Tube	0.700Inches	± 0.010	0.710 0.690	Diameter .7

Plex 9/20/18 3:08 PM Dart.lajeunesse.marie



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Container No: S131509



Part: D2282-5

Job No: 183579

Serial No/Batch: S131509

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/26/18